

Work Order ID 114782

March-12-14 7:19:26 AM

114782

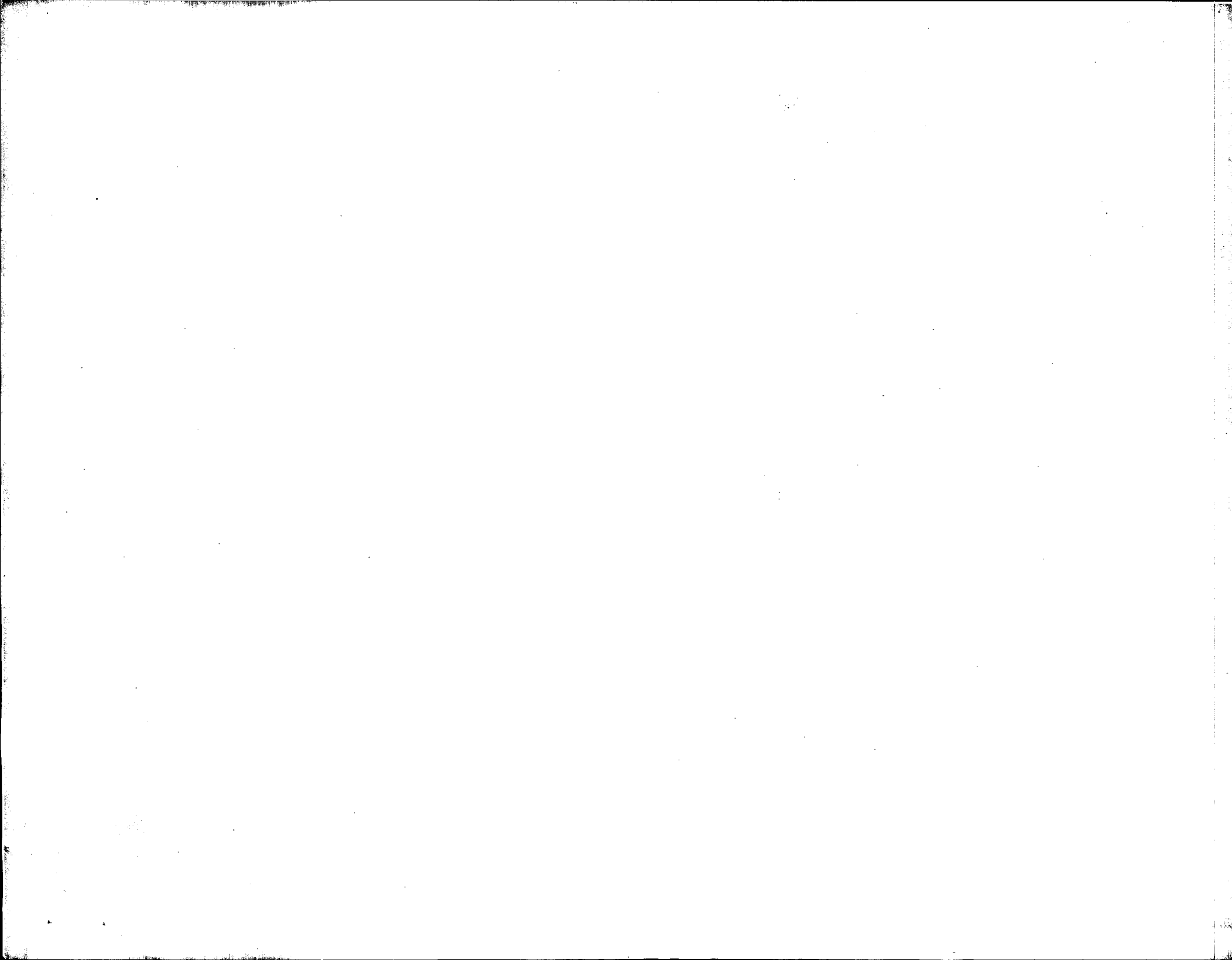
Page 2

Item ID:	D4092-042	Accept	*N19000040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Maintenance Step Assembly					
Start Date:	3/12/14	Start Qty:	8.00	*g*	Cust Item ID:	
Required Date:	3/24/14	Req'd Qty:	8.00	*g*	Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location:	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14-03-17



March-12-14 7:19:25 AM

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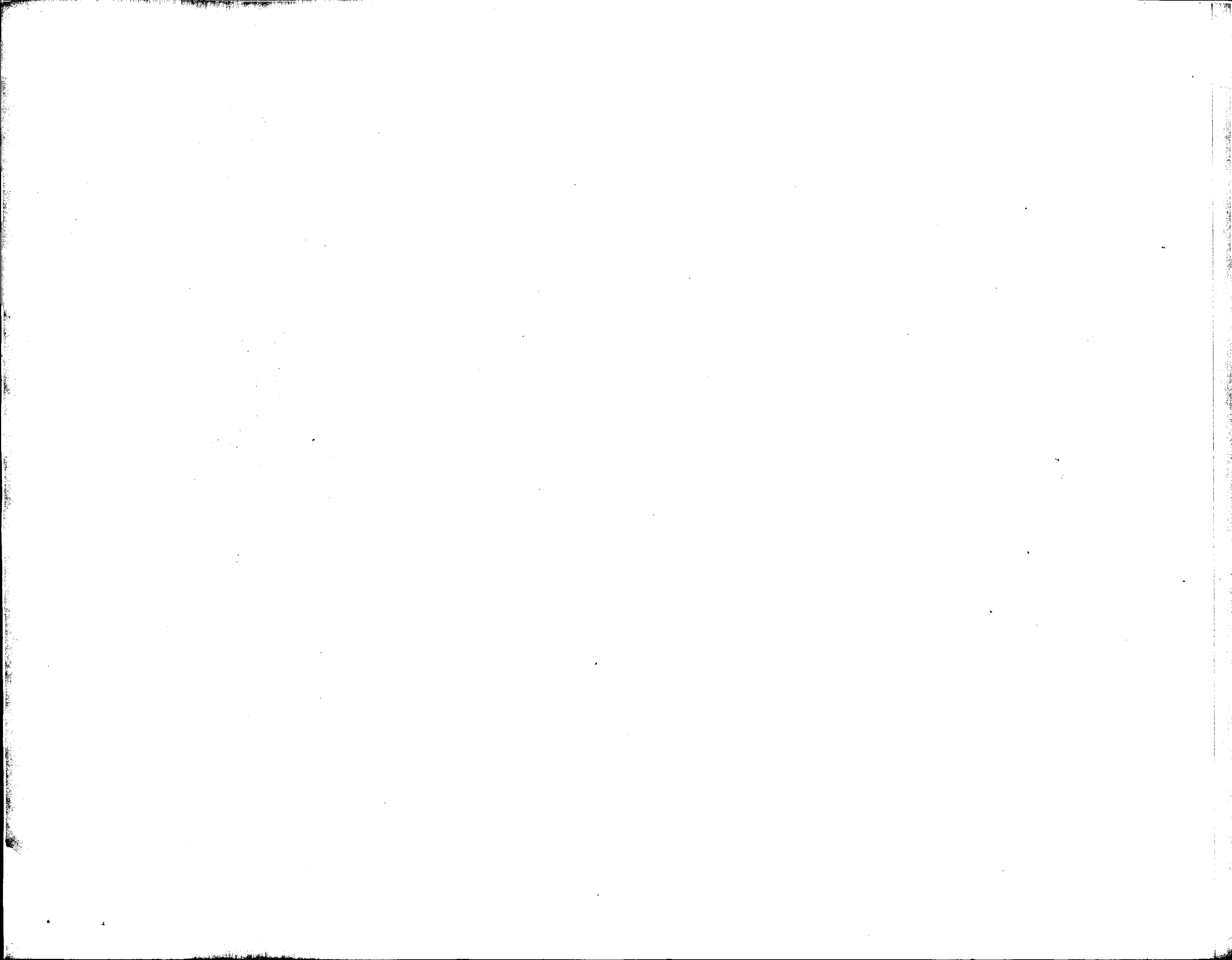
D4092-042

Required Date: 3/24/14

Required Qty: 8.00

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1		Manufactured	No				Each	5.0000		16			DAS 36 9-89
D4092-1									**			14/03/13	
Maintenance Step													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST270				5					
					110087			5					
D4093-1		Manufactured	No				Each	1.0000		8			DAS 28 9-89
D4093-1									**			14-03-12	
Bracket													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST270				1					
					108292			1					
D4093-3		Manufactured	No				Each	0.0000		8			DAS 28 9-89
D4093-3									**				
Bracket													
D4093-5		Manufactured	No				Each	4.0000		16			DAS 36 9-89
D4093-5									**			14/03/13	
Bracket													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST270				4					
					110076			4					



Picklist Print

March-12-14 7:19:25 AM

Page 2

Work Order ID: 114782

114782

Parent Item: D4092-042

D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 3/12/14

Required Date: 3/24/14

Start Qty: 8.00

Required Qty: 8.00

MS24694-S54

Purchased

No

Each

244.0000

16

MS24694-S54

SCREW

DAS
28
9-89

Location

Loc Qty

Loc Code

ST303

244

125535

244

16x

MS24694-S55

Purchased

No

Each

449.0000

64

MS24694-S55

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST303

449

m127327

99

m128401

150

m128402

200

27x

37x

MS24694-S56

Purchased

No

Each

185.0000

16

MS24694-S56

SCREW

DAS
28
9-89

Location

Loc Qty

Loc Code

ST303

185

m126400

85

m128402

100

125535

16x

March-12-14 7:19:26 AM

Shop Packet Print

Page 2

Picklist Print

March-12-14 7:19:26 AM

Page 3

Work Order ID: 114782

114782

Parent Item: D4092-042

D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 3/12/14

Required Date: 3/24/14

Start Qty: 8.00

Required Qty: 8.00

NAS1149D0332J

Purchased

No

Each

881.0000

96

NAS1149D0332.I

Washer

**

DAS

28

9-89

14-03-12

Location

Loc Qty

Loc Code

GA

179

m127916

179

ST293

410

m127389

25

m127431

385

ST294

5

m125807

5

ST510a

287

m127916

287

96x

MS21042L3

Purchased

No

Each

4,530.000

96

MS21042L3

Nut

**

DAS

28

9-89

Location

Loc Qty

Loc Code

ST314

3575

M127410

2534

M127831

41

M128401

1000

ST506

955

123900

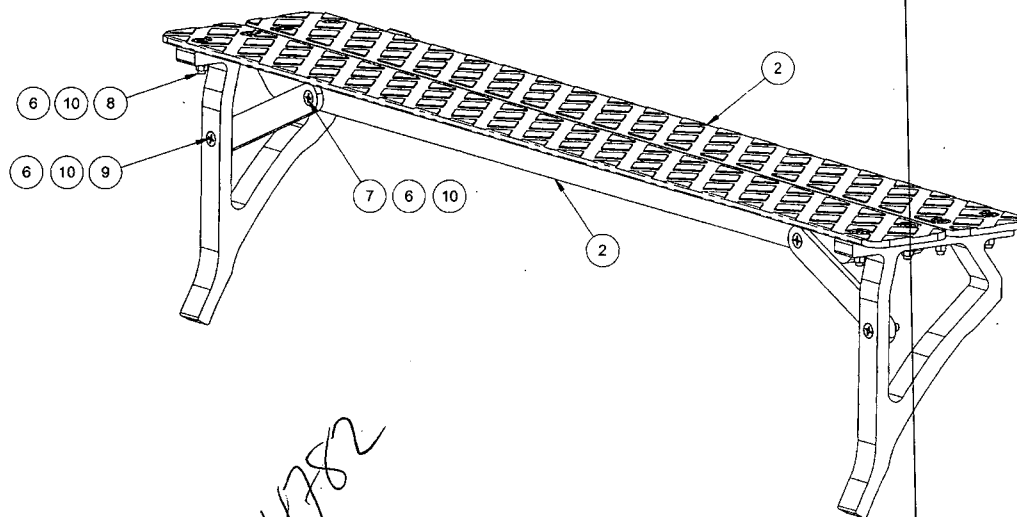
955

96x

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Shop Packet Print

Page 3

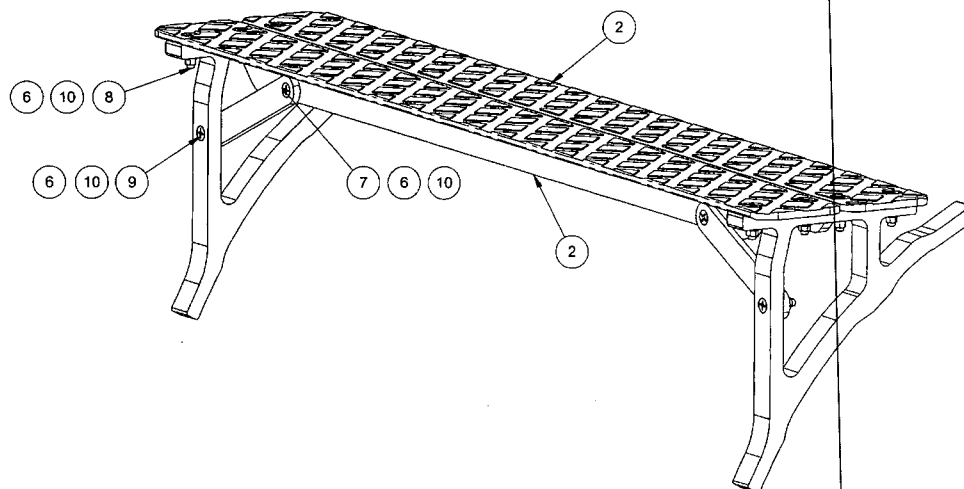


D4092-041 MAINTENANCE STEP ASSEMBLY

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

RELEASED
2011-09-22

B	REDRAWN; LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	140	D4092	SHEET 1 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	MAINTENANCE STEP ASSY	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



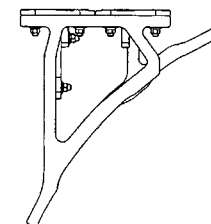
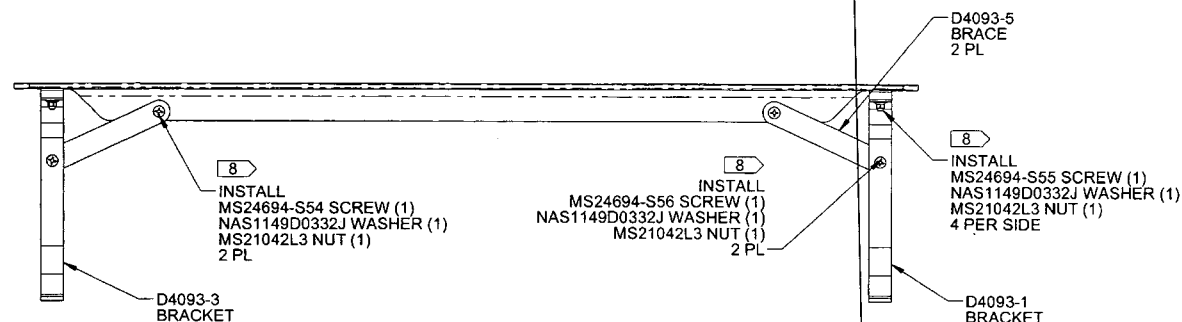
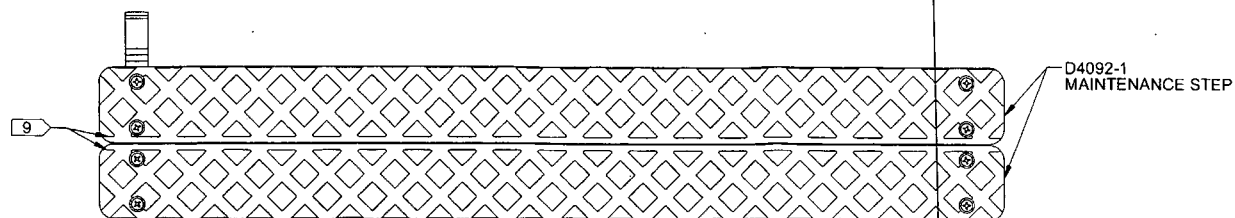
D4092-042 MAINTENANCE STEP ASSEMBLY



ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

RELEASED
2011-09-22
JW

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D4092	SHEET 2 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	MAINTENANCE STEP ASSY	NTS
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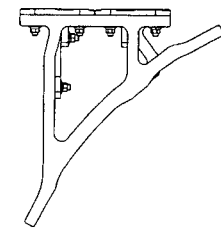
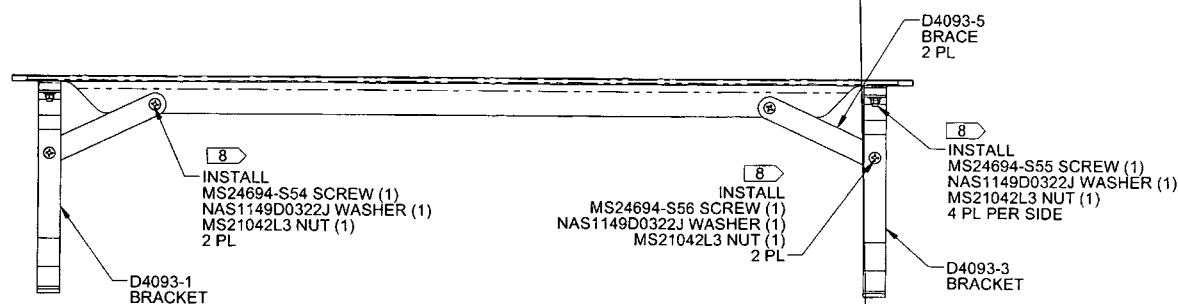
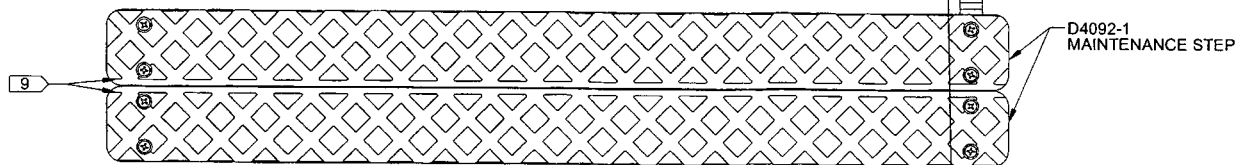
D4092-041 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4092	SHEET 3 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASSY	NTS
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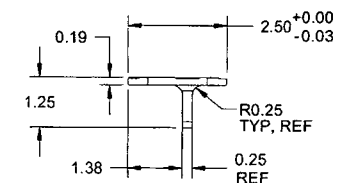
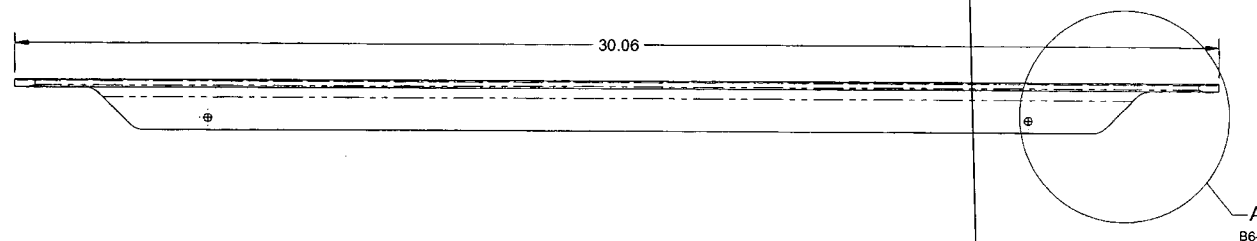
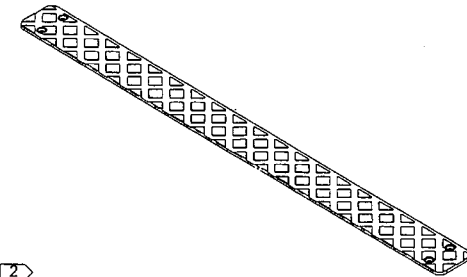
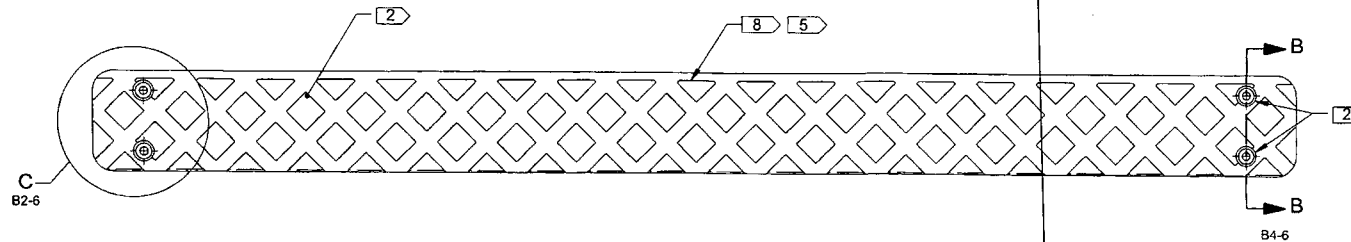


D4092-042 MAINTENANCE STEP ASSEMBLY

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: PER QSI 044 6.1
 7) WEIGHT: 5.37 lbs
 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
 9) GRIP CUTOUT TOWARD CENTER

RELEASED
 2011-09-22

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MFG. APPR.	<i>RF</i>	D4092	SHEET 4 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASS'Y	NTS
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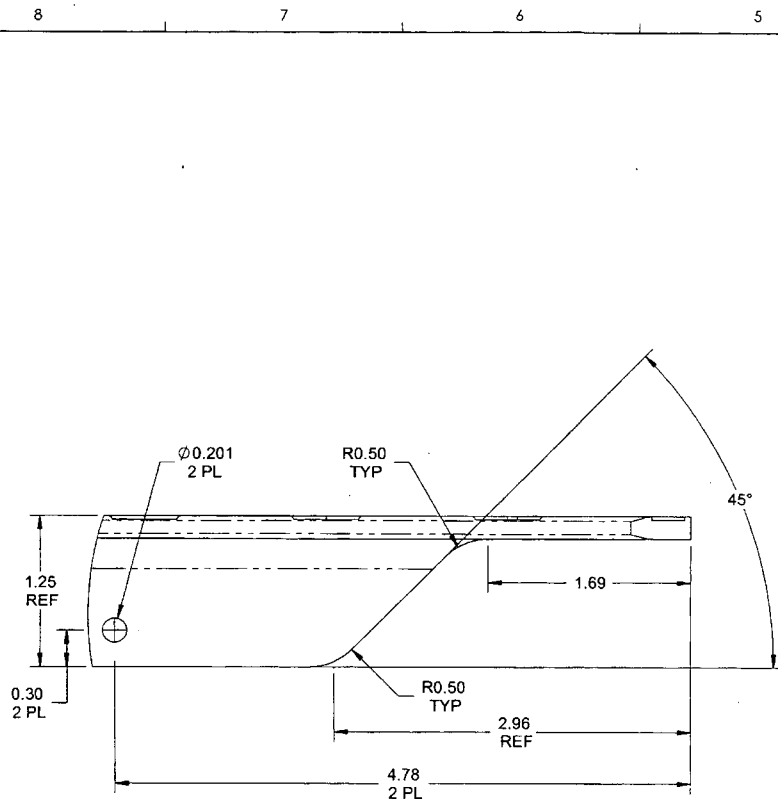
D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

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2011-09-22
JWW

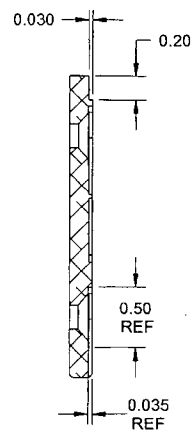
NOTES:

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

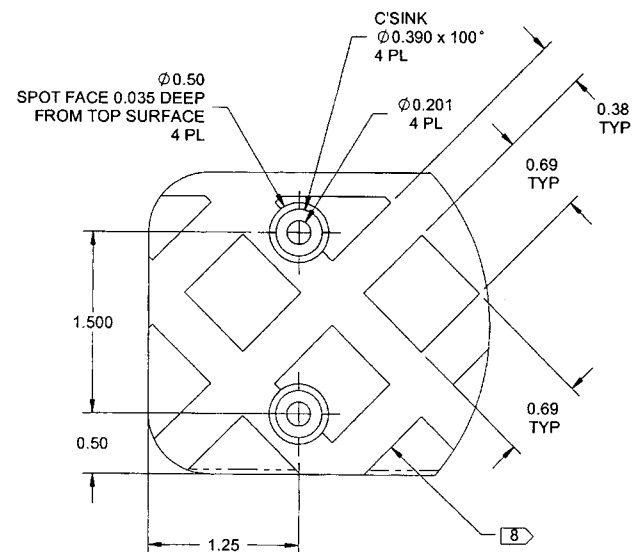
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DRAWN	RF	KENT, WA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D4092	SHEET 5 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	MAINTENANCE STEP ASSY	NTS
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DETAIL A B3-5
SCALE 3X, TYP



SECTION B-B C3-5
SCALE 3X, TYP



DETAIL C C8-5
SCALE 3X, TYP

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2011-09-22
WFO

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MFG. APPR.	<i>RF</i>	D4092	SHEET 6 OF 6
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